

# Work Order ID 98635

March-18-13 3:00:05 PM

**\*98635\***

Page 1

Item ID: D4434-9

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 3/18/13 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 3/22/13 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: W

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4434

B

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-9 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

10 0 Jm 3-3-18

10 0 Jm 3-3-18

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Item ID: D4434-9 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket  
 Start Date: 3/18/13 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 3/22/13 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00 13319				10			
130 *130* Small Fab Small Fab	Memo C'SINK AS PER DWG	0.00 0.00				10			13/03/20
140 *140* Brake NC Brake NC	Bend as per dwg  Memo	0.00 0.00				10			13/03/21

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March-18-13 3:00:05 PM

Item ID: D4434-9 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 3/18/13 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 3/22/13 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		<i>SinP</i> <i>13321</i>		<i>10</i>			
160 <b>*160*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				<i>10</i>	<i>13322</i>		
170 <b>*170*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00		<i>DAS</i> <i>27</i> <i>13322</i>		<i>10</i>			

**\*98635\***

March-18-13 3:00:05 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 3/18/13      **Start Qty:** 10.00      **\*10\***

**Cust Item ID:**

**Required Date:** 3/22/13      **Req'd Qty:** 10.00      **\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

Identify as per dwg & Stock Location: ~~ST~~ GA 0.00

**\*210\***

## Packaging

## Packaging

## Memo

0.00

10x

13-3-22

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

## Quality Control

## Memo

0.00

17/3/25

MF  
13-3-25

# Picklist Print

March-18-13 3:00:04 PM

Page 1

Work Order ID: 98635

Parent Item: D4434-9

Parent Item Name: Bracket

Start Date: 3/18/13

Required Date: 3/22/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 12.01.24 AS PER DWG REV.A DD VERF:EC IPP Rev:B 12.03.06 per  
REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	698.7156	0.24	<del>25263158</del>			
										2.6		JM 13-3-13	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT021		698.7156							
				121099		273.7156							
				123874		425							
								123874					

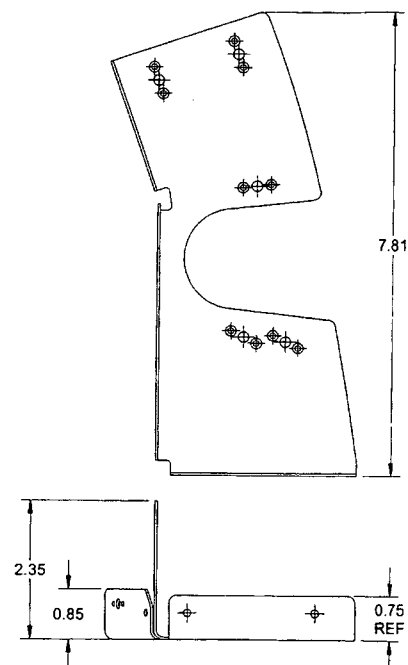
98655

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: Jm	Audited by: [Signature]	Preliminary Approval:
Date: 13-3-18	Date: 15-3-19	Date:

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	







R0.13  
TYP

0.75  
2 PL

**B** **D4434-9 BRACKET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D4434-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4434</b>	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>COVER ASSEMBLY</b>	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
2012-03-03  
MM

W/O 98635

